

Work Order ID 54670

December 16, 2009 9:21:03 AM



Page 1

Item ID: PB67-43001-229

Accept



Setup Start



Revision ID:

Stop



Item Name: Outer Tube

Start Date: 12/16/09 Start Qty: 2.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B67-43001

C B1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- cut to length and cut angle on one end of tube as per dwg
2- deburr

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes and mill slot as per dwg PB67-43001
2- deburr

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control



Work Order ID 54670

December 16, 2009 9:21:03 AM



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Item ID: PB67-43001-229

Accept



Setup Start



Revision ID:

Item Name: Outer Tube

Stop



Start Date: 12/16/09 Start Qty: 2.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Weld end cap as per dwg PB67-43001 2- grind weld flush								
140 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
150 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

2

12/16/09

2) 8/10/01/04

42

8/10/01/04

42

Work Order ID 54670

December 16, 2009 9:21:04 AM



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Item ID: PB67-43001-229

Accept



Setup Start



Revision ID:

Stop



Item Name: Outer Tube

Start Date: 12/16/09 Start Qty: 2.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00				10-1-5		2X	54
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							10/01/06
Quality Control									

U 10-02-05

Picklist Print

December 16, 2009 9:21:02 AM

Page 1

Work Order ID: 54670

Parent Item: PB67-43001-229

Parent Item Name: Outer Tube

Comments:

Start Date: 12/16/09

Required Date: 12/31/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			100	f	33.8200	10.7895			
6061T6 RDTUBE 1.750 X 0.65W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

33.82

108551

2.24

109397

0.4

110885

16.69

111432

14.49

PB67-43001-233

Manufactured

No

130

Each

7.0000

2.0000

Outer Tube End Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

41573

7

sell cross w/o attached

sell cross w/o attached

Work Order ID 47092

December 11, 2009 8:58:16 AM

Page 1

Item ID: PB67-43001-29

Accept

Setup Start

Revision ID: B1

Stop

Item Name: Blade Positioner Weldment

Start Date: 15/07/2009 Start Qty: 2.00

Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100		0.00							
	Large Fab								
	Large Fab	0.00							
	Large Fab								
	Memo								
	****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO WELDING****□1- ASSEMBLE AND WELD AS PER DWG								
110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
	QC	0.00							
	Quality Control								
	Memo								
120		0.00							
	QC5- Inspect part completeness to step on W/O								
	QC	0.00							
	Quality Control								
	Memo								

Re-issued
on 5/4/70

W. 9-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 47092

December 11, 2009 8:58:16 AM



Page 2

Item ID: PB67-43001-29

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Blade Positioner Weldment

Start Date: 15/07/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo START TIME: _____ FINISH TIME: _____	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 47092

December 11, 2009 8:58:16 AM



Page 3

Item ID: PB67-43001-29

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Blade Positioner Weldment

Start Date: 15/07/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
	Packaging	0.00							
	Memo								
	Packaging								
170	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Memo								
	Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

December 11, 2009 8:58:20 AM

Work Order ID: 47092

Parent Item: PB67-43001-29RevB1

Parent Item Name: Blade Positioner Weldment

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Comments:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

December 11, 2009 8:59:08 AM

Parent Item: PB67-43001-29RevB1

Parent Item Name: Blade Positioner Weldment

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 08/04/2009 10:59:31 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OUTER TUBE
Job Number : 47092
Estimate Number : 13501
P.O. Number :
This Issue : 08/04/2009 S.O. No. :
Prsht Rev. : NC Part Number : PB6743001229
First Issue : / / Type : MACHINED PARTS Drawing Number : B6743001 P.19
Previous Run : 45258 Drawing Revision : B1
Material :
Due Date : 15/04/2009 Qty: 2 Um: Each
Written By :
Checked & Approved By : MF 09-04-08
Comment : Est Rev:A 08-07-24 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

✓

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 5.3813 f(s)/Unit Total : 10.7625 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M11432

SA 09/04/23

2.0

✓

BAND SAW

BAND SAW



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length and cut angle on one end of tube as per dwg

2- deburr

SA 09-12-14

3.0

✓

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes and mill slot as per dwg PB67-43001 USING DT8792

2- deburr

SA 09/04/22

4.0

✓

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

✓

PB6743001233

Outer Tube Partial End Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Outer Tube Partial End Cap

= 2 x

SA 09/12/14
B41573

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 08/04/2009 10:59:31 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER TUBE

Job Number: 47092

Part Number: PB6743001229

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- bend end cap to fit on tube
2- Weld end cap as per dwg PB67-43001
3- grind weld flush

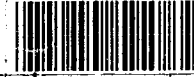
PL 08/12/14

7.0



QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5/10/01/08 x2

8.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

10.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

